

# Work Order ID 77205

\*77205\*

Page 1

November-29-11 9:50:20 AM

Item ID: D350-604-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Rear Locker Extender

Start Date: 29/11/2011 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 19/12/2011 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/29

Tooling:

Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2273	D
D350-604-041	A
DSI9470	A

100 0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8 11/12/20

MLJ 11-12-19  
①

110 0.00

\*110\*

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15563  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 118800

CL 11/11/29 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77205

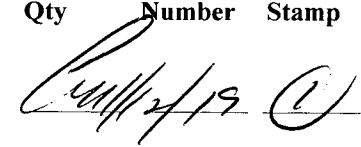
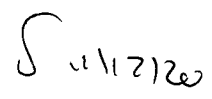
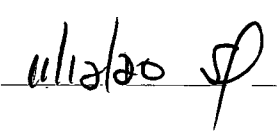
**\*77205\***

Page 2

November-29-11 9:50:20 AM

Item ID: D350-604-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rear Locker Extender  
 Start Date: 29/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 19/12/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Packaging  Memo Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.	0.00  0.00							
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Check hole locations to template. DT 8824 Check process sheet and audit.	0.00  0.00							
140 <b>*140*</b> Packaging Packaging	Pick Kit  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 77205****\*77205\***

Page 3

November-29-11 9:50:20 AM

Item ID: D350-604-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Locker Extender

Start Date: 29/11/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 19/12/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC4- 100% Inspect kits for completeness 0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

**\*160\***

Packaging

Packaging

Memo

0.00

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

170

**\*170\***

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Quality Control

11/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-29-11 9:50:27 AM

Page 1

Work Order ID: 77205

\*77205\*

Parent Item: D350-604-041

\*D350-604-041\*

Parent Item Name: Rear Locker Extender

Start Date: 29/11/2011

Required Date: 19/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

2600-6*		Purchased	No			110	Each	120.0000	4	4			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

\*2600-6\*

Camlock Stud

\*\*

*CD 11/11/29*

Location

Loc Qty

Loc Code

ST380

120

118611

1

118800

29

118852

90

D350-604-041P

Purchased

No

120

Each

0.0000

1

1

\*D350-604-041P\*

Rear Locker Extender

\*\*

*11/11/19*

D2268

Manufactured

No

140

Each

13.0000

1

1

\*D2268\*

Decal

\*\*

*59*

Location

Loc Qty

Loc Code

ST009

13

69592

2

74520

11

D2269

Manufactured

No

140

Each

9.0000

1

1

\*D2269\*

Decal

\*\*

*11/12/20*

Location

Loc Qty

Loc Code

ST009

9

74521

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

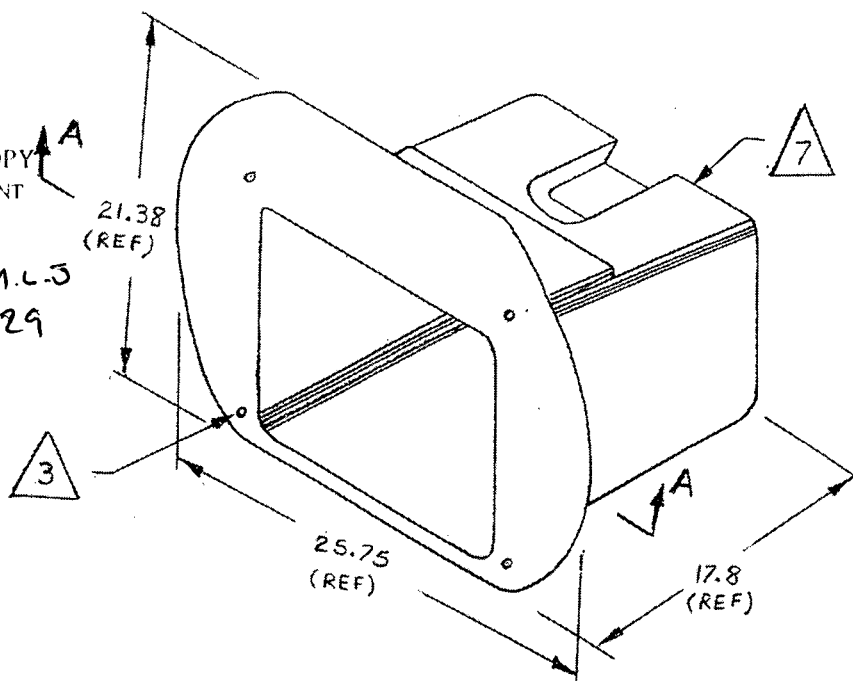




DESIGN JB	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE 02.04.01		TITLE 350 REAR LOCKER EXTENDER	SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

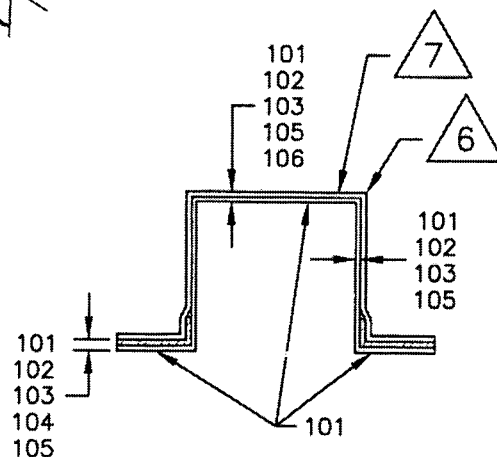
RELEASED  
02.04.03 *[Signature]*

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77205 M.C.3  
11/11/29



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERA KANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
A1	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED  
02.04.03 [Signature]

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77205 M.L.J  
11/11/29

RETAINING WASHER  
2600-LW (4)



INSTALL D2728-1 DECAL  
IN DEPRESSION ON INSIDE  
BACK WALL

CAMLOCK STUD  
2600-4 (4)



DECAL (D2268)  
TOTAL WEIGHT IN THIS COMPARTMENT  
NOT TO EXCEED 15 LBS (7 KGS)

### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	41626
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
15/12/2011	30/11/2011	19422	Chantal Lavoie		PO15563		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	LINE #1 Rear Locker Extender D350-604-041P B77204 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div>No. série B77204</div> <div>No. lot 36520</div>			
1	0	1	DKC134-0003	LINE #2 Rear Locker Extender D350-604-041P B77205 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div>No. série B77205</div> <div>No. lot 37027</div> <div>S 11/12/20</div>			
1	0	1	DKC134-0003	LINE #3 Rear Locker Extender D350-604-041P B77206 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <div>No. série B77206</div> <div>No. lot 37031</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2011-11-08 12:37:38  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD	Nom Dessin : REAR LOCKER EXTENDER
Numéro Job : 37027	Numéro Article : DKC134-0003
Numéro Soumission : 3482	Numéro Dessin : D350-604-041 & D2273
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2011-11-08 No. B.V. :	Révision dessin : A & D
Prsht Rev. : NC	Matériel : Derakane 470-36/411/510
Prem. fois : - - Type :	Date Due : 2011-11-15 Qté: 1 Udm: UNITE
Job précédente : 36523	

Écrit par : \_\_\_\_\_  
Vérifié & Approuvé par : \_\_\_\_\_  
Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
N° de pièce Assemblage Dart Aerospace: D350-604-041

**B77205**

Process Sheet Rév.: 03 Modifier la séq. 6 Prep-general.

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 14 Nov 11 Sceau:



2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total: 1.580 UNITE(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-32675-1

3.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747 Acetone

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 10-Nov-11 Sceau:



Date: , Mardi, 2011-11-08 12:37:38  
Utilisateur: Pascale Parignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37027

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003.

Date: 14-Nov-11 Sceau:



7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 14-Nov-11 Sceau:



8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
-----	---------	---

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-32912-1

9.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2

11.0	AMB0213	WR1850 Roving 18oz. x 50"
------	---------	---------------------------

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50" N° de Lot: 1-32516-1

12.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 33% Température: 70.3 Heure: 4:00

Quantité: 1 Date: 14-11-11 Sceau:



Date: Mardi, 2011-11-08 12:37:38  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37027

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

13.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: N/A



14.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: N/A



15.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: 1

Date: 15 NOV 11

Sceau:



LB.



16.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1

Date: 15 NOV 11

Sceau:



17.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run: 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 16-11-11

Sceau:



18.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-30270-

19.0

AAC1001

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2



Date: Mardi, 2011-11-08 12:37:38  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37027

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Quantité: 1

Date: 25 NOV. 2011

Sceau:

Description:



26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057

Quantité: 1

Date: 25 NOV. 2011

Sceau:



par 24 nov 11  
Job 37027